

Date: Friday, 9/7/2007 10:14:33 AM
User: Kim Johnston

Process Sheet

SPR 11/2/03

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : TAIL LIGHT FAIRING
Job Number : 34461
Estimate Number : 12363
P.O. Number : N/A Part Number : D34846
This Issue : 9/7/2007 S.O. No. : N/A Drawing Number : D3484 REV D
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB Drawing Revision : D
Previous Run : 30775 Material : N/A
Written By : Due Date : 9/14/2007 Qty: 10 Um: Each
Checked & Approved By :
Comment : Est Rev. A New Issue 06-04-11 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S050 6061-T6 .050 Sheet



Comment: Qty.: 0.2904 sf(s)/Unit Total : 2.9043 sf(s)

6061-T6 .050 Sheet

(M6061T6S050)

Batch: 117347

SAD

07/09/08

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

Cut as per Dwg D3484

Dwg D
Ing R

SAD

07/09/08

1P

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD

07/09/08

1P

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

En

07/09/08

counter

(11)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

SAD

07/09/13

(11)

2-Roll as per Dwg D3484

07/11/29

X11

FF 07-12-13

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/12/13	5	Took 3 pieces of (3484) D 3484-2 for w/o D 3484-1 too make into part even on both w/o same Batch # of the material	<i>[Signature]</i>	N/A	<i>[Signature]</i>	SD 07/12/13	<i>[Signature]</i>	<i>[Signature]</i>

NOTE: Date & initial all entries

Date: Friday, 9/7/2007 10:14:33 AM

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TAIL LIGHT FAIRING

Job Number: 34461

Part Number: D34846

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 07/12/13 (6)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WS

DD 07-12-17 (6)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2 07/12/18 (6)

Job Completion



2 07/12/17

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

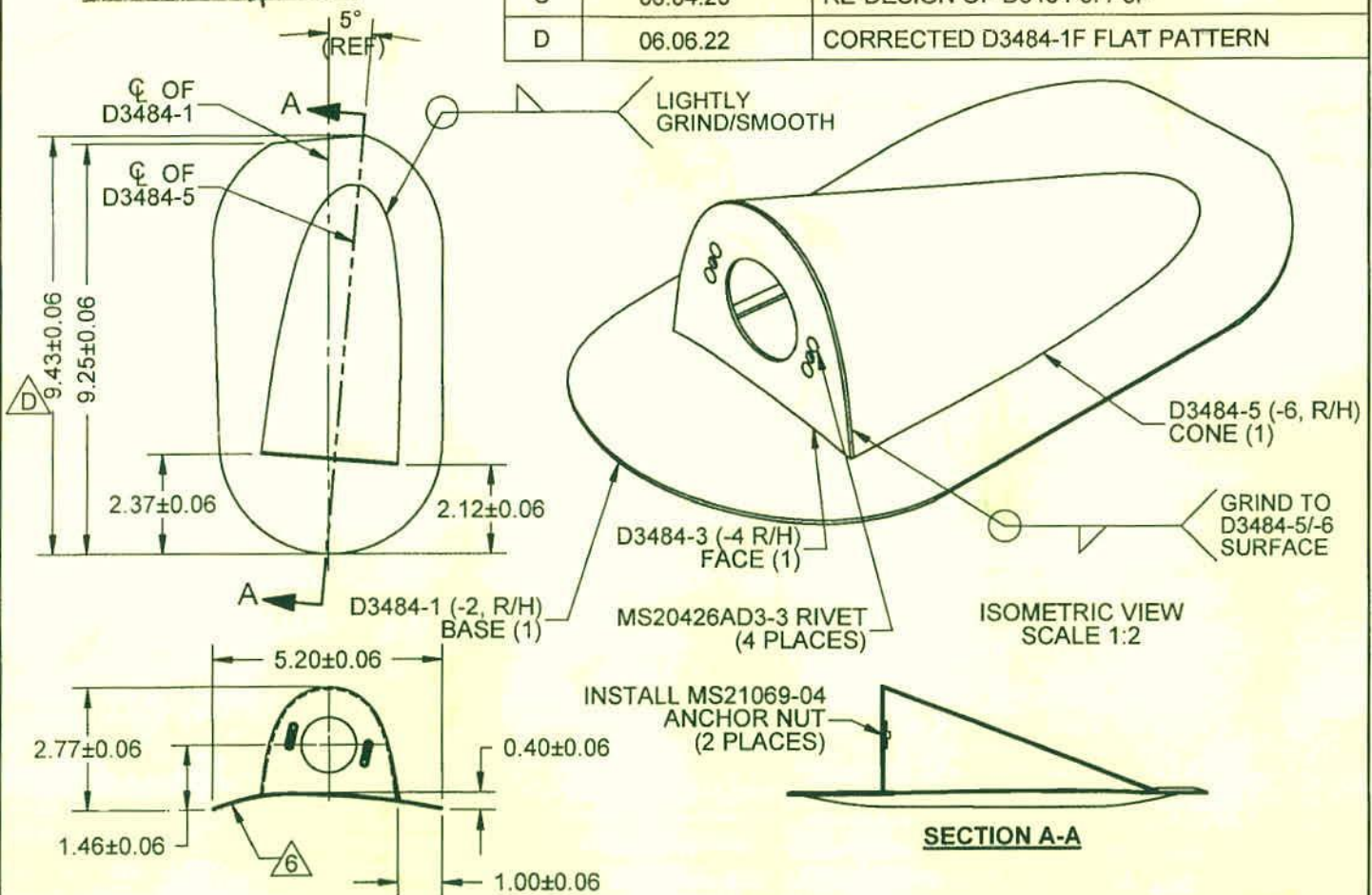
NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3484	REV. D SHEET 1 OF 4
DATE	06.06.22	TITLE TAIL LIGHT FAIRING	SCALE 1:4
A	05.11.29	NEW ISSUE	
B	06.02.21	RE-DESIGN	
C	06.04.20	RE-DESIGN OF D3484-3F/-5F	
D	06.06.22	CORRECTED D3484-1F FLAT PATTERN	

RELEASED

06.08.17

**D3484-041 TAIL LIGHT FAIRING, L/H (SHOWN), R/H (OPPOSITE)****NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED WITH WHITE LABEL:
"TCCA-PDA, DART AEROSPACE LTD.,
P/N D412-750-141/-142 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE
PDA06-13"

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3484-041	TAIL LIGHT FAIRING ASSEMBLY (L/H)
	X	D3484-042	TAIL LIGHT FAIRING ASSEMBLY (R/H)
1		D3484-1	BASE (L/H)
	1	D3484-2	BASE (R/H)
1		D3484-3	FACE (L/H)
	1	D3484-4	FACE (R/H)
1		D3484-5	CONE (L/H)
	1	D3484-6	CONE (R/H)
4	4	MS20426AD3-3	RIVET
2	2	MS21069-04	ANCHOR NUT

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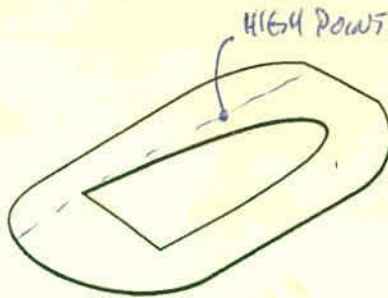
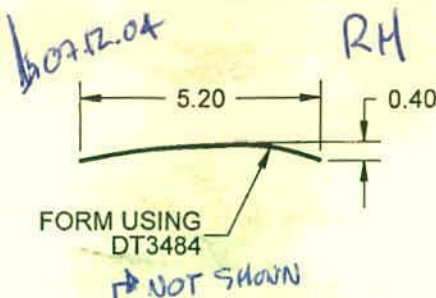
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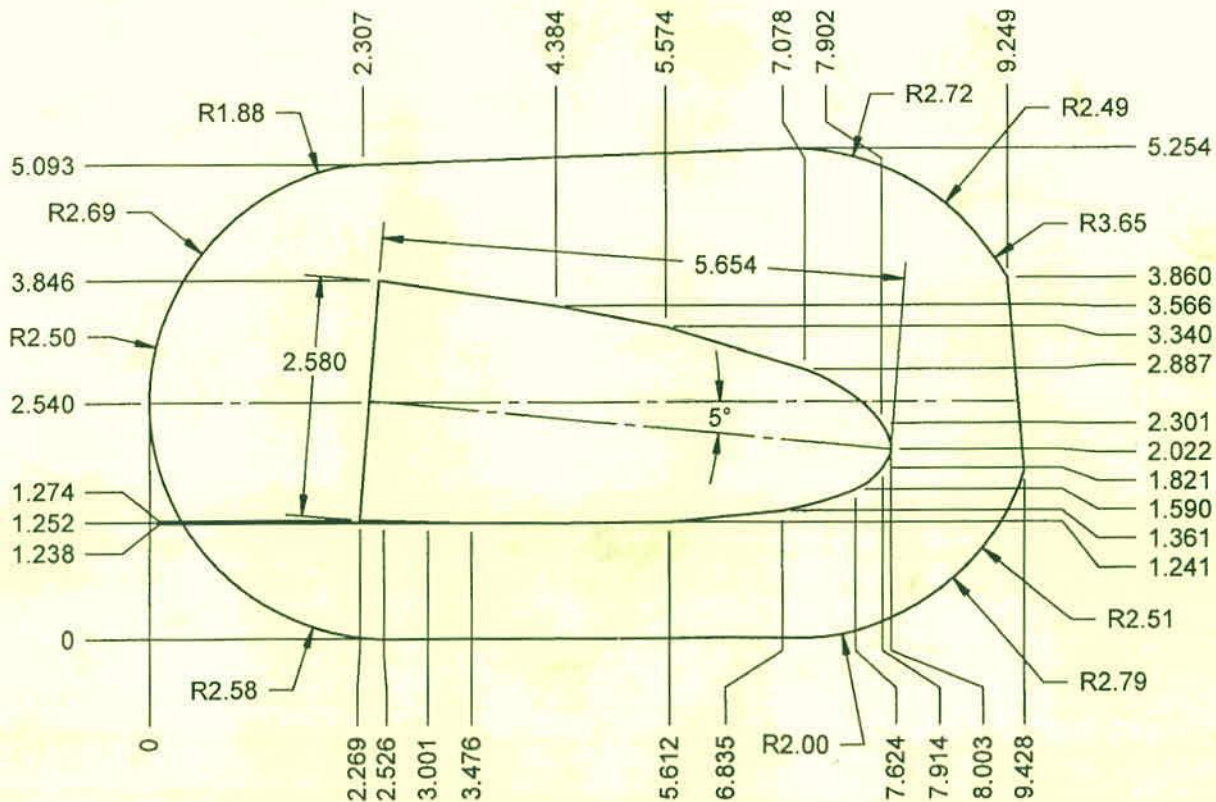
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CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3484	REV. D SHEET 2 OF 4
DATE 06.06.22	TITLE TAIL LIGHT FAIRING		SCALE 1:2

**D3484-1 BASE, L/H****D3484-1 BENDING DETAIL**

(D3484-2 OPPOSITE) *SHOWN*
(MAKE FROM D3484-1F)

**D3484-2 BASE, R/H****D3484-1F BASE FLAT PATTERN** **NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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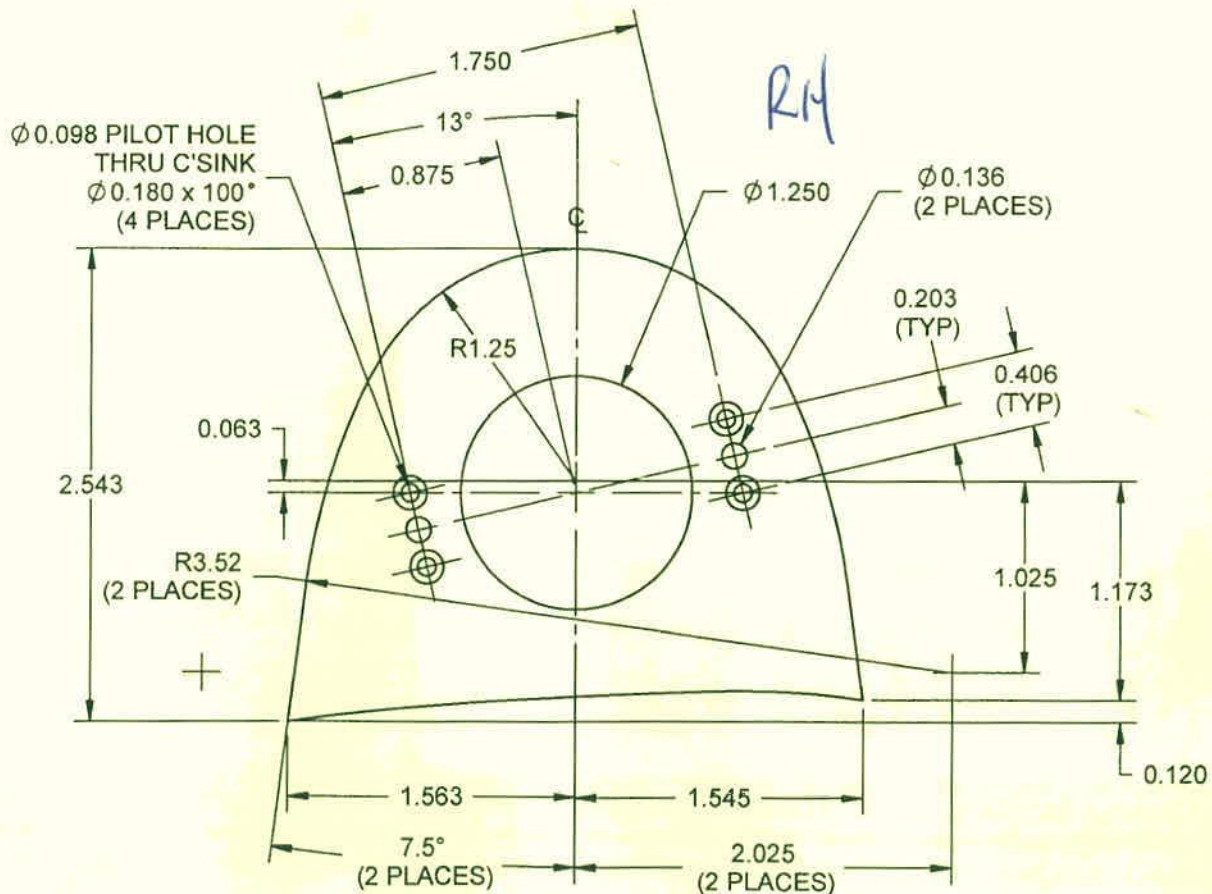
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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3484	REV. D SHEET 3 OF 4
DATE 06.06.22	TITLE TAIL LIGHT FAIRING		SCALE 1:1

**D3484-3 L/H FACE (-4 R/H, OPPOSITE)****NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

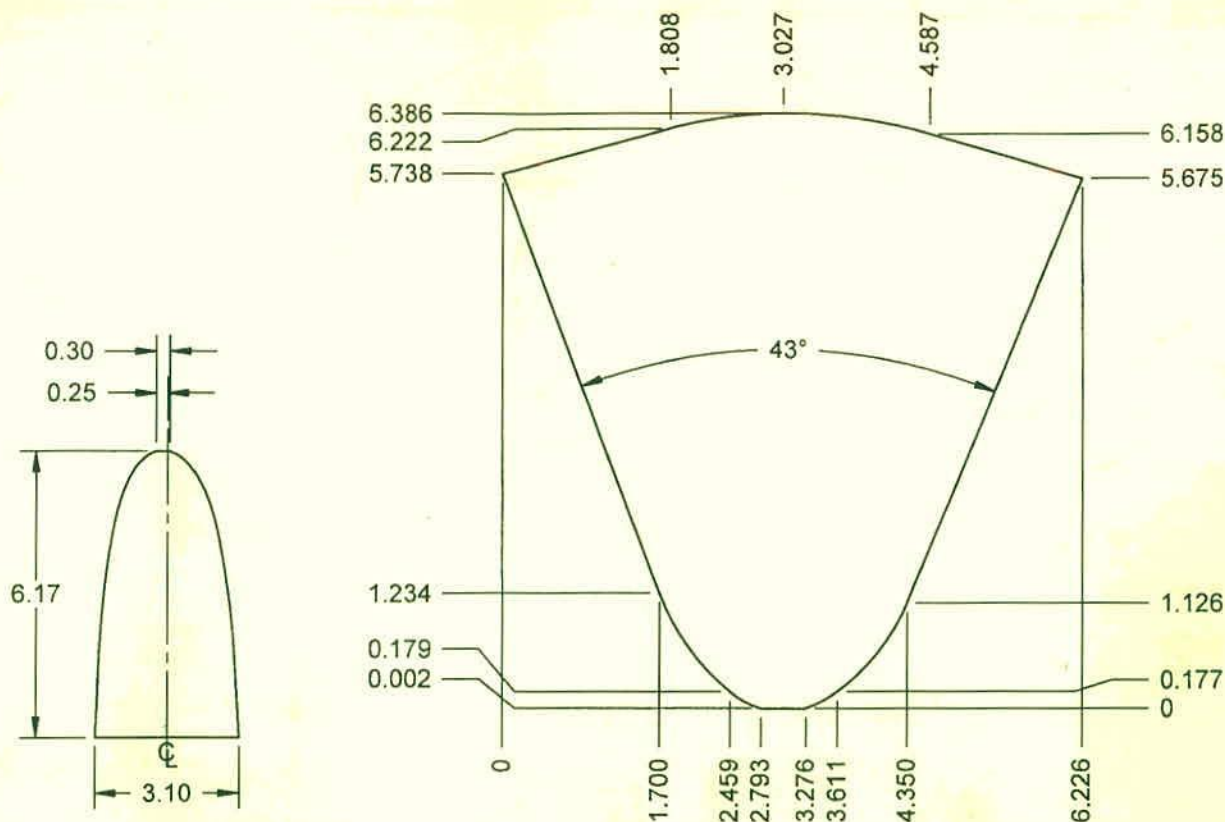
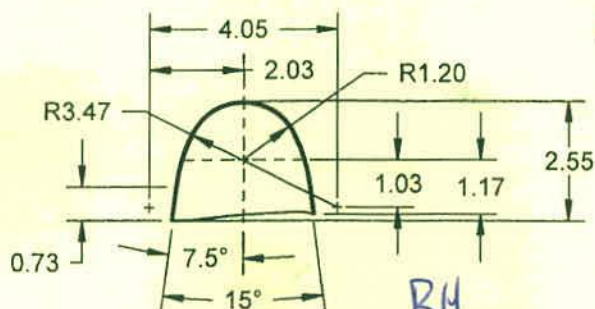
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CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3484	REV. D SHEET 4 OF 4
DATE 06.06.22		TITLE TAIL LIGHT FAIRING	SCALE 1:4

**D3484-5F CONE FLAT PATTERN****D3484-5 L/H CONE BENDING DETAIL (-6 R/H, OPPOSITE)
(MAKE FROM D3484-5F)****NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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